



Dart Hawkesbury
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

RB T101529-131
Job Sheet 167907



5038736

Part No: RB T101529-131

Job Qty: 1 ea

Part Name: Roll Stake Tool, Tail Rotor Blade



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 11/8/17

Job Tracking No:

Due Date: 12/19/17

Created By: Chantal Lavoie

Type: Stock

Description:

Customer: Aerochine Aviation Limited (CAEAV01)

Room 1817, Building B, Ningbo Chamber of Commerce, Tiantong Road No 588, Yinzhou District Ningbo, Zhejiang, 315000 China ph:86(0)574-8281 7586 fx:86(0)574-8281 7586.

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Purchasing	1 pcs		12/19/17	0.00	0.00	Purchasing		SP18-01-10
110	Packaging	1 pcs		12/19/17	0.00	0.00	Packaging2		SP18-01-10
120	QC	1 pcs		12/19/17	0.00	0.00	QC6		38
130	Packaging	1 pcs		12/19/17	0.00	0.00	Packaging3 GA		AT 18-01-12
140	QC21-FG	1 Ea		12/19/17	0.00	0.00	QC21		

Part Op 100 - Issue P/O: 38295 MANUFACTURE RB T101529-131 AS PER DWG Supplier: METEC Certificate of Descriptions: conformity is required

DAS
13
9-59

NOV 08 2017

Job Allocations

Operation	Component Part	Required	Inventory	Allocated	Std Qty
100-Purchasing	RB T101529-131P	1	0	0	0

Part Specifications

Specifications could not be found.

Plex 11/8/17 7:14 AM dart.lavoie.chantal

DART
AEROSPACE
S030747

Dart Aerospace Ltd.

1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL.: 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com



Roll Stake Tool, Tail Rotor Blade

PART NO: RB T101529-131

Revision:

Operation:

Change No:

Purchasing

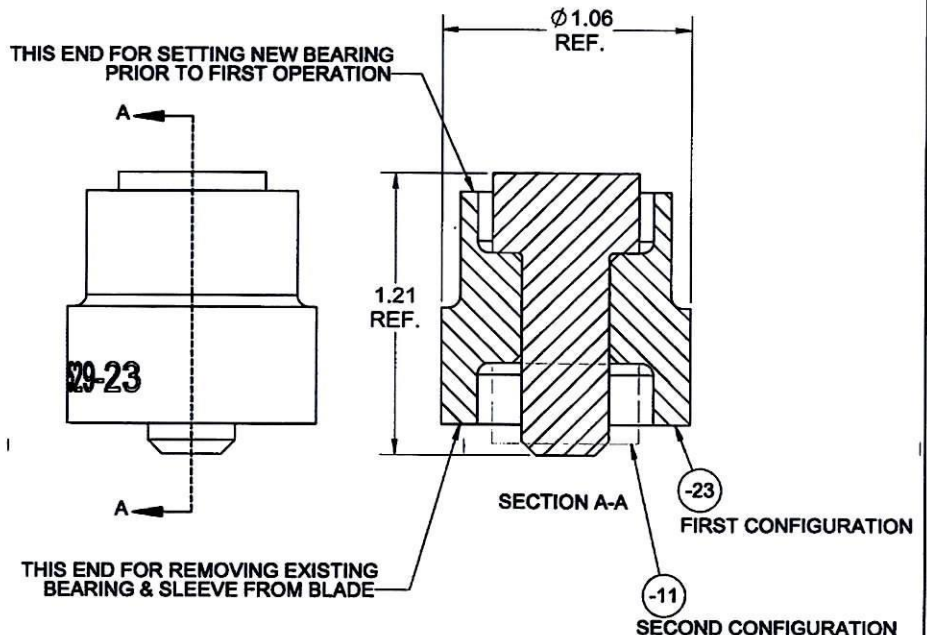
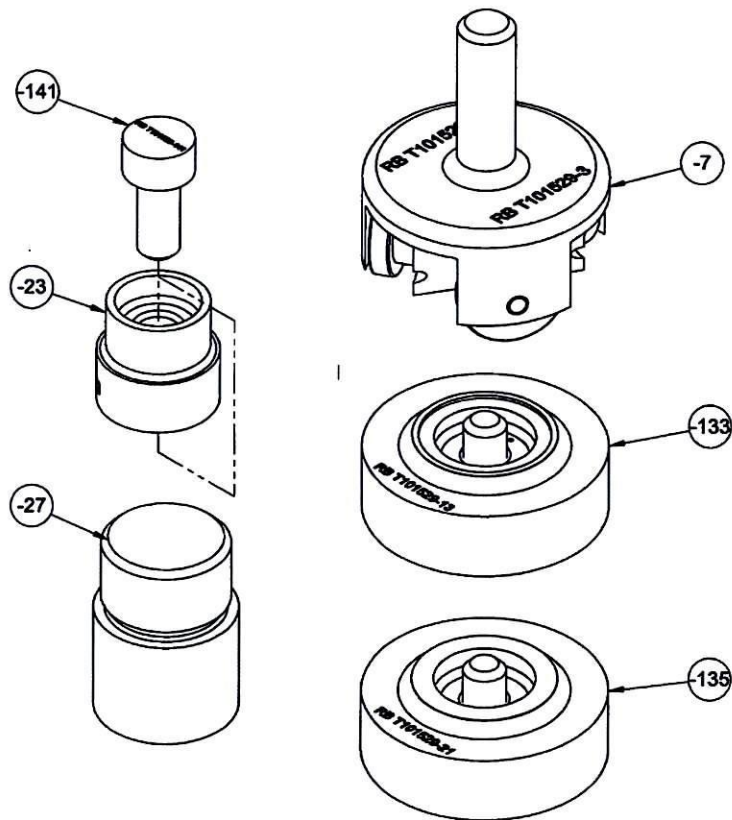
Mfg Date: 01/10/18

Job No: 167907

80 6 weeks

Purchased B+R - Metco

ITEM #	QTY	PART #	TITLE	PG	REV.	DESCRIPTION	DATE	BY	APPROVED
-7	1	RB T101529-7	HOUSING ASSY	2	A	NEW ISSUE	17.09.12	VM	WM
-133	1	RB T101529-133	BASE 1 ASSY	5					
-135	1	RB T101529-135	BASE 2 ASSY	8					
-141	1	RB T101529-141	PILOT	10					
-23	1	RB T101529-23	PUNCH & SET	11					
-27	1	RB T101529-27	SUPPORT	12					

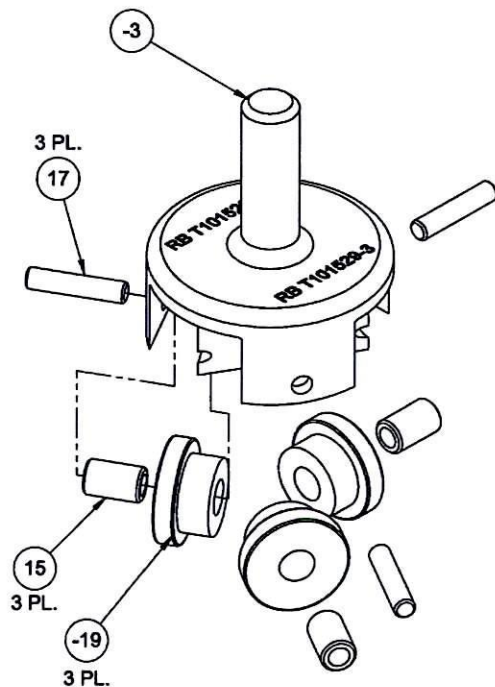


- NOTES:**
- 1) MATERIAL: N/A
 - 2) FINISH: N/A
 - 3) HEAT TREAT: N/A
 - 4) SPEC: N/A
 - 5) BREAK ALL SHARP EDGES: N/A
 - 6) IDENTIFICATION: N/A
 - 7) OEM PART# T101529

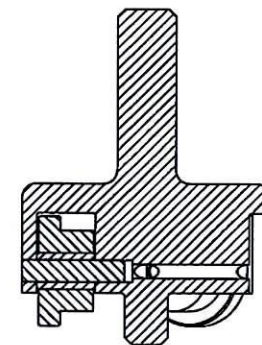
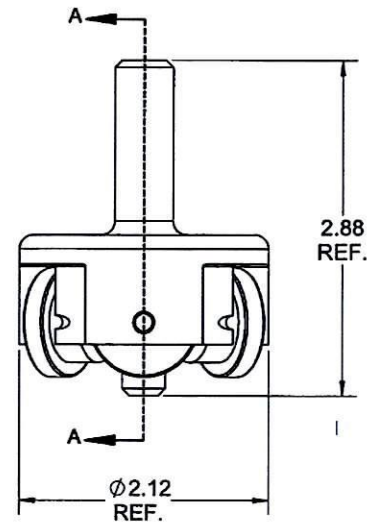
RB T101529-131 ROLL STAKE TOOL, TAIL ROTOR BLADE

DART AEROSPACE Newbury, Ontario, Canada	
TITLE ROLL STAKE TOOL, TAIL ROTOR BLADE	
DWG NO. RB T101529-131	REV A
DESIGN BY: VM 9/11/2017	CHECKED BY: VM 10/23/2017
DRAWN BY: VM 10/23/2017	CHECKED BY: SAC 10/23/2017
APPROVED BY: DP 10/30/2017	DATE: 10/23/2017
SCALE: NTS WEIGHT: N/A SHEET 1 OF 12	
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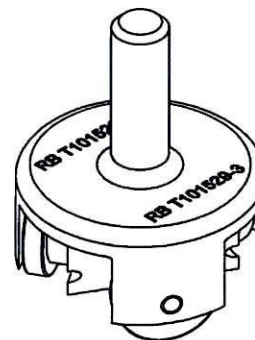
ITEM #	QTY	PART #	TITLE	PG
-19	3	RB T101529-19	ROLLER	3
-3	1	RB T101529-3	HOUSING	4
15	3	McMaster#9368T43	HIGH-TEMP DRY-RUNNING SLEEVE BEARING	-
17	3	McMaster#98381A509	DOWEL PIN STEEL 3/16" DIA x 7/8" LG.	-



RB T101529-7 HOUSING ASSY

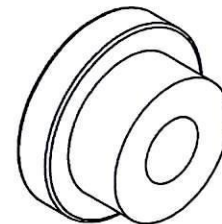
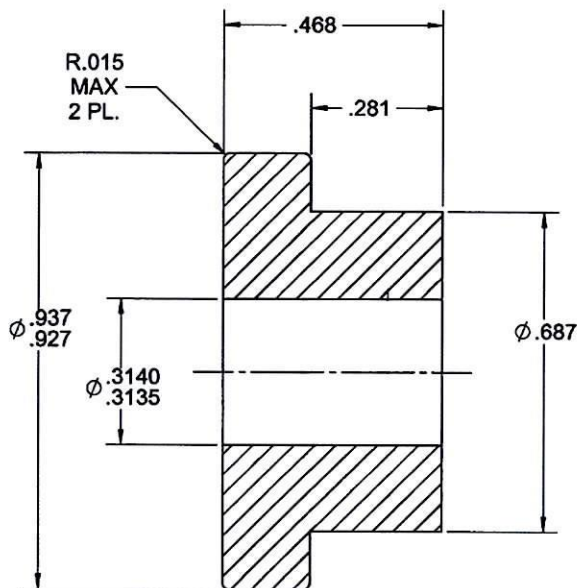
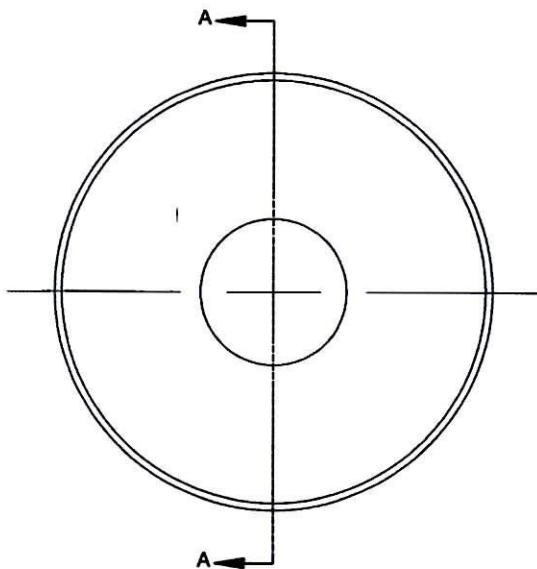


SECTION A-A



- NOTES:
- 1) MATERIAL: N/A
 - 2) FINISH: N/A
 - 3) HEAT TREAT: N/A
 - 4) SPEC: N/A
 - 5) BREAK ALL SHARP EDGES: N/A
 - 6) IDENTIFICATION: N/A

DART AEROSPACE Hawkesbury, Ontario, Canada	
TITLE HOUSING ASSY	
DWG NO. RB T101529-7	REV A
DESIGN BY: VM 9/11/2017	CHK VM 10/23/2017
DRAWN BY: VM 10/23/2017	CHECKED: SAC 10/23/2017
MFG. APPR: DP 10/30/2017	DATE: 10/23/2017
APPROVED: WM 11/02/2017	SCALE: NTS
WEIGHT: N/A	SHEET 2 OF 12
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RB T101529-19 ROLLER

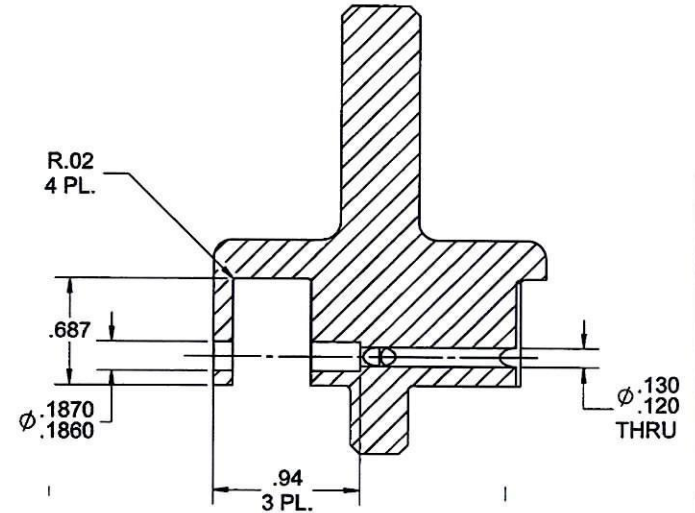
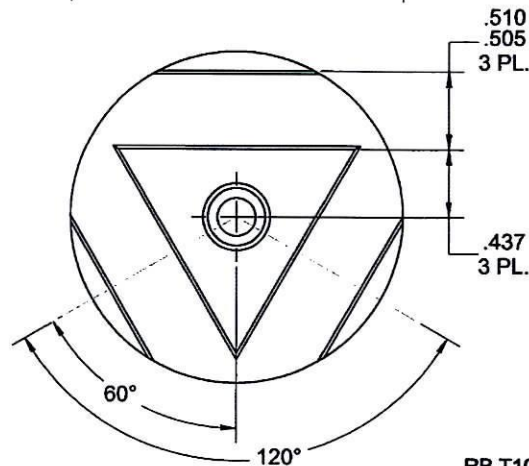
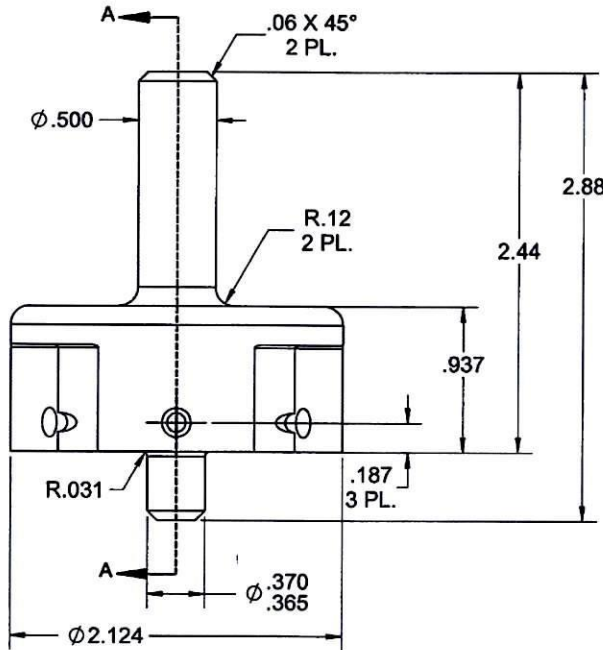
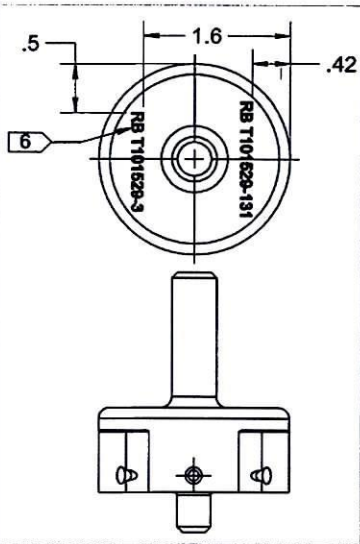
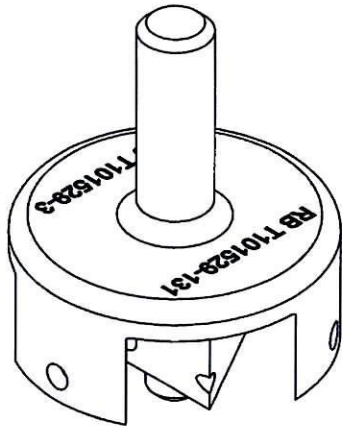
SECTION A-A

NOTES:

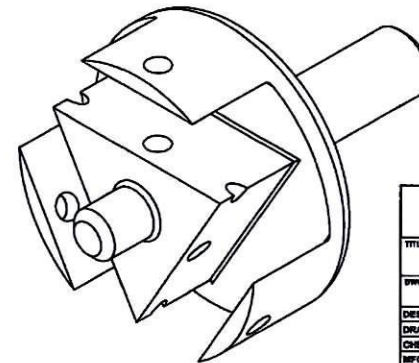
- 1) MATERIAL: AISI 4130
- 2) HEAT TREAT: 25 Rc
- 3) FINISH: N/A
- 4) SPEC: N/A
- 5) BREAK ALL SHARP EDGES .015 x 45° OR .015R
- 6) IDENTIFICATION: N/A

DART AEROSPACE Hawkebury, Ontario, Canada	
ROLLER	
RB T101529-19	
REV A	
DESIGN BY: VM 9/11/2017	XXX 2 .005 FRACTIONS & 1/8
DRAWN BY: VM 10/23/2017	XX 1/16 ANGLES & 5°
CHECKED: SAC 10/23/2017	1. DIMENSIONS ARE IN INCHES
MPG. APPR: DP 10/30/2017	UNLESS OTHERWISE SPECIFIED
APPROVED: WM 11/02/2017	2. INTERPRET DIM AND TOL. PER
DATE: 10/23/2017	ASME Y14.5M-2009
3. DIMENSIONAL LIMITS APPLY AFTER PLATING	
SCALE: NTS	WEIGHT: 0.1 LBS
SHEET 3 OF 12	
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8 7 6 5 4 3 2 1



SECTION A-A
3 PL. 120°



RB T101529-3 HOUSING

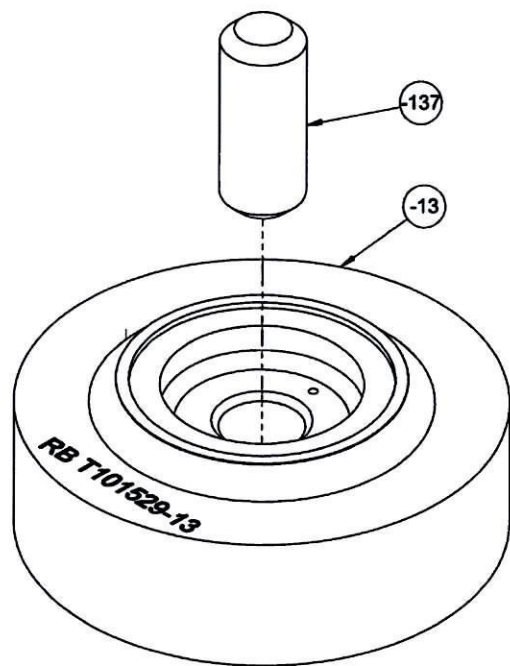
NOTES:

- 1) MATERIAL: AISI 4130
- 2) HEAT TREAT: 25 Rc
- 3) FINISH: N/A
- 4) SPEC: N/A
- 5) BREAK ALL SHARP EDGES .015 x 45° OR .015R
- 6) IDENTIFICATION: MACHINE ENGRAVE "RB T101529-131" & "RB T101529-3", ARIAL REGULAR, 1/8" HEIGHT, 0.010" DEPTH

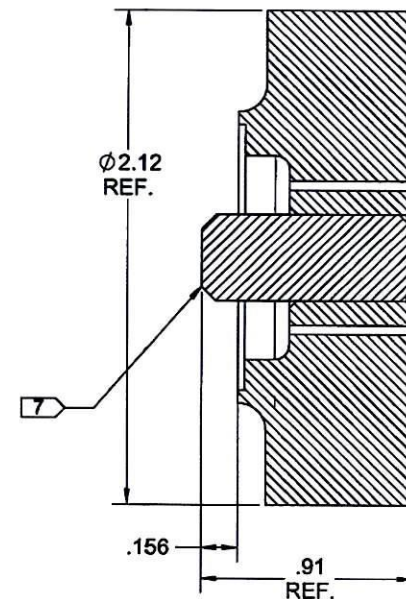
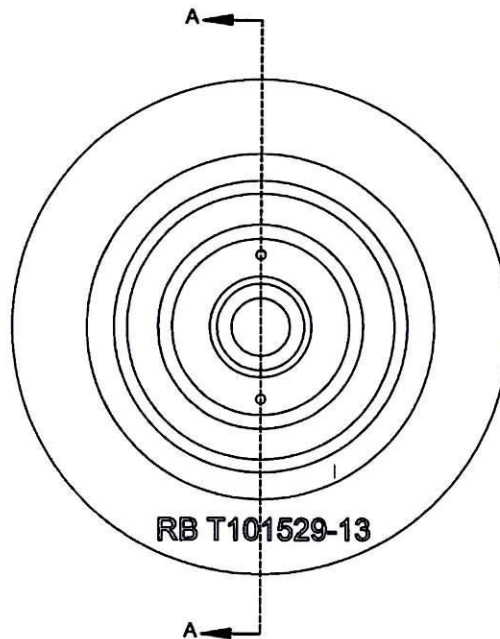
DART AEROSPACE Hawkebury, Ontario, Canada			
TITLE HOUSING			
PART NO. RB T101529-3			
DESIGN BY: VM 9/11/2017			REV A
DRAWN BY: VM 10/23/2017			
CHECKED BY: SAC 10/23/2017			
APPROVED BY: DP 10/30/2017			
DATE: 10/23/2017			
SCALE: NTS	WEIGHT: 0.6 LBS	SHEET 4 OF 12	
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8 7 6 5 4 3 2 1

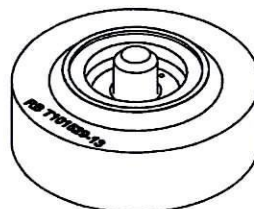
ITEM #	QTY	PART #	TITLE	PG
-13	1	RB T101529-13	BASE 1	6
-137	1	RB T101529-137	PIN	7



RB T101529-133 BASE 1 ASSY



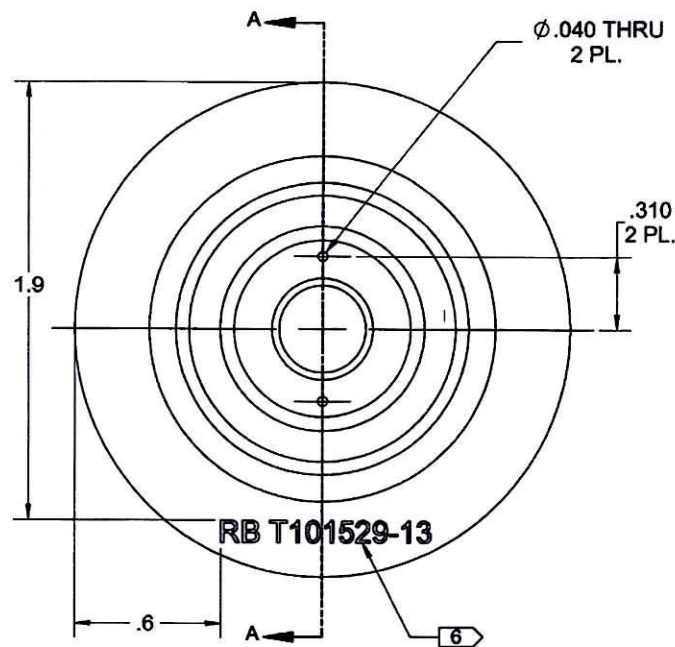
SECTION A-A



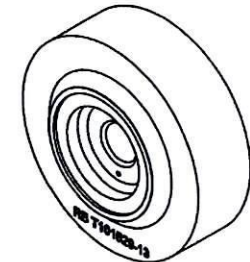
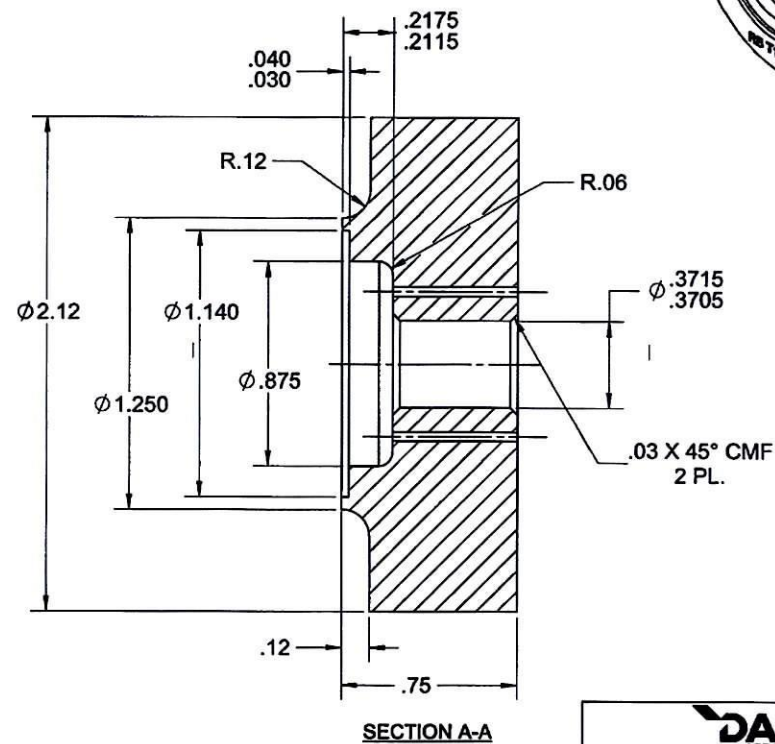
NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: N/A
- 3) HEAT TREAT: N/A
- 4) SPEC: N/A
- 5) BREAK ALL SHARP EDGES: N/A
- 6) IDENTIFICATION: N/A
- 7) PRESS FIT RB T101529-137 INTO RB T101529-13

DART AEROSPACE		Hawkebury, Ontario, Canada	
BASE 1 ASSY			
RB T101529-133			
DESIGN BY: VM 9/11/2017		XXX 2 2017 FRACTIONS 2/16	
DRAWN BY: VM 10/23/2017		XX 2 41 ANGLES 5.5°	
CHECKED: SAC 10/23/2017		X 1 SURFACES = 125°	
MFG. APPROV: DP 10/30/2017		1. DIMENSIONS ARE IN INCHES	
APPROVED: WM 11/02/2017		2. UNLESS OTHERWISE SPECIFIED	
DATE: 10/23/2017		3. DIMENSIONAL LIMITS APPLY	
SCALE: NTS		WEIGHT: N/A	
		SHEET 5 OF 12	
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RB T101529-13 BASE 1

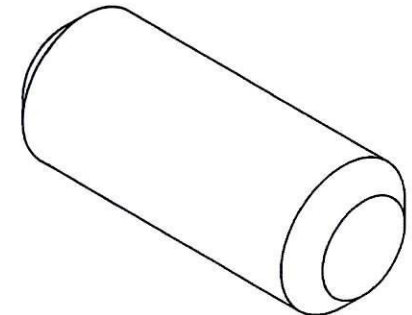
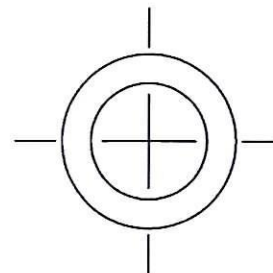
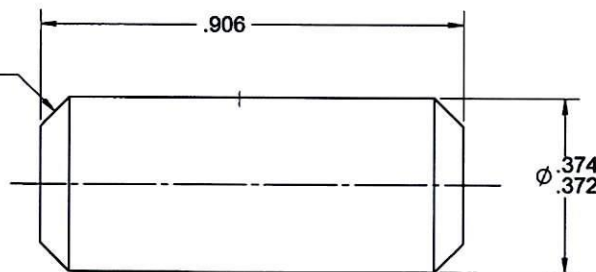


NOTES:

- 1) MATERIAL: AISI 4130
- 2) HEAT TREAT: 25 Rc
- 3) FINISH: N/A
- 4) SPEC: N/A
- 5) BREAK ALL SHARP EDGES .015 x 45° OR .015R
- 6) IDENTIFICATION: MACHINE ENGRAVE "RB T101529-13", ARIAL REGULAR, 0.09" HEIGHT, 0.010" DEPTH

DART AEROSPACE Newbury, Ontario, Canada	
BASE 1	
RB T101529-13	
DESIGN BY: VM 9/11/2017	JOCK 2.000 FRACTIONS 2/16
DRAWN BY: VM 10/23/2017	3X 1/16 ANGLES 45°
CHECKED: SAC 10/23/2017	1. DIMENSIONS ARE IN INCHES
INFO. APPR: DP 10/30/2017	2. INTERPRET DIM AND TOL PER
APPROVED: VM 11/02/2017	ASME Y14.5M-2009
DATE: 10/23/2017	3. DIMENSIONAL LIMITS APPLY
SCALE: NTS	WEIGHT: 0.6 LBS
SHEET 8 OF 12	
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.06 X 45° CMF
2 PL.



RB T101529-137 PIN

replace this part with off the shelf
adjust tolerances in mating parts to match

if changing to off the shelf component, need to verify
dimensions and probably be used as-is without
modification
give this part, change to purchase part, verify -17
and give work with on the shell then 13

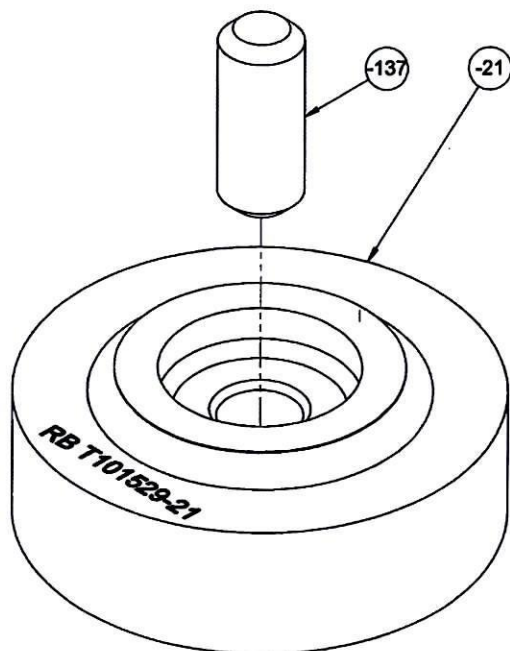
need to be more specific on grade of bronze

NOTES:

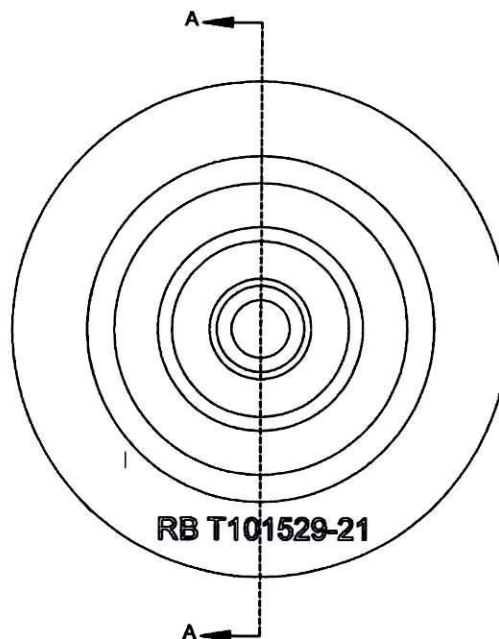
- 1) MATERIAL: AISI 4130
- 2) HEAT TREAT: 25 Rc
- 3) FINISH: N/A
- 4) SPEC: N/A
- 5) BREAK ALL SHARP EDGES .015 x 45° OR .015R
- 6) IDENTIFICATION: N/A

DART AEROSPACE			
Hawkebury, Ontario, Canada			
TITLE			
PIN			
DWG NO.		REV	
RB T101529-137		A	
DESIGN BY:	VM 8/11/2017	JOCK ± .005	FRACTIONS ± 1/8
DRAWN BY:	VM 10/23/2017	XX ± .01	ANGLES ± 1°
CHECKED:	SAC 10/23/2017	XX ± .1	SURFACES ± 125
MFG. APPR:	DP 10/30/2017	1. DIMENSIONS ARE IN INCHES	
APPROVED:	WM 11/02/2017	2. INTERPRET DIM AND TOL PER ASME Y14.5M-2009	
DATE:	10/23/2017	3. DIMENSIONAL LIMITS APPLY AFTER PLATING	
SCALE:	NTS	WEIGHT:	0.0 LBS
		SHEET 7 OF 12	
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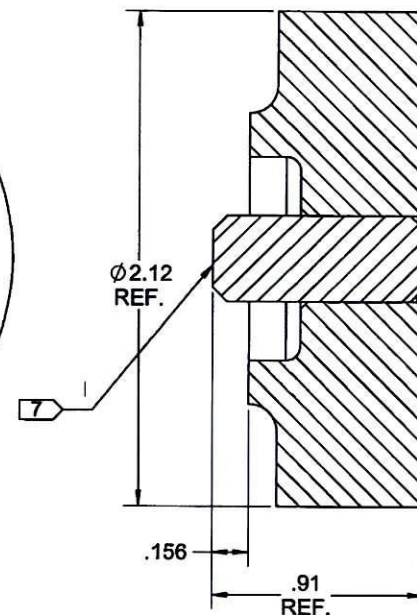
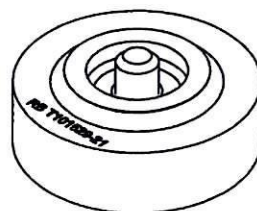
ITEM #	QTY	PART #	TITLE	PG
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-21	1	RB T101529-21	BASE 2	9



RB T101529-135 BASE 2 ASSY



RB T101529-21



SECTION A-A

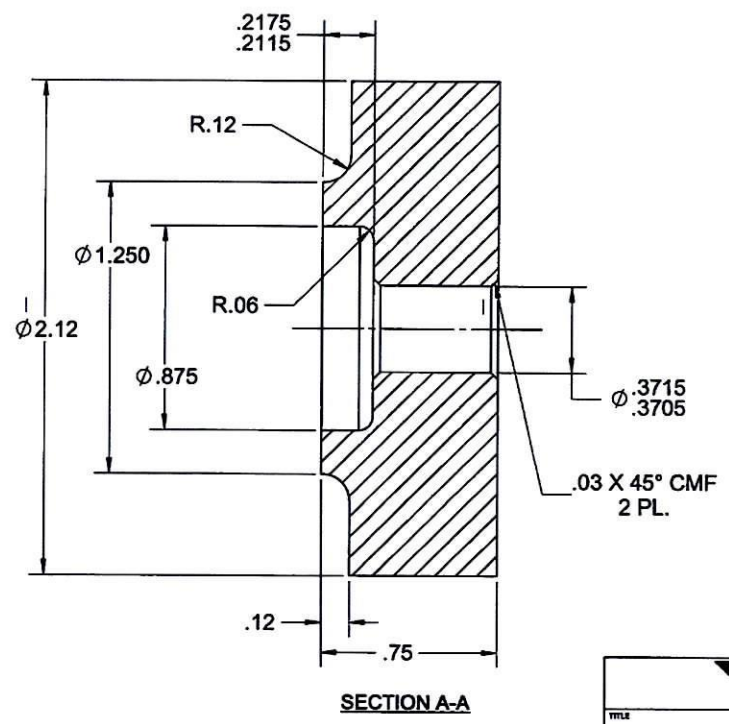
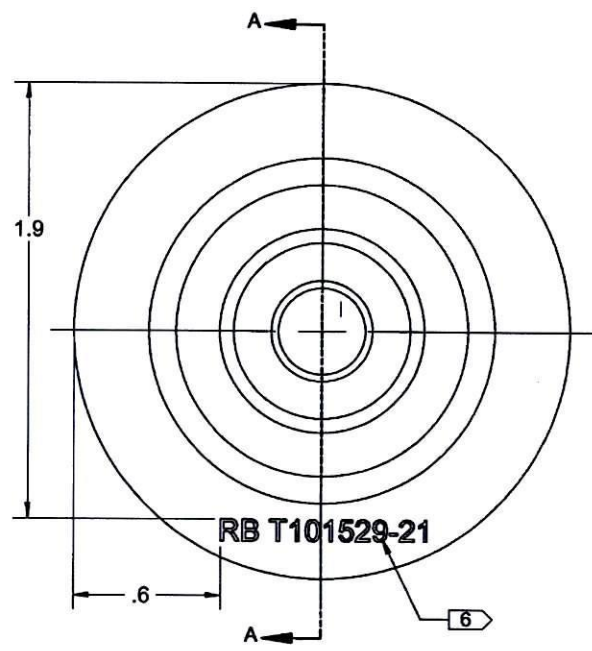
- NOTES:
- 1) MATERIAL: N/A
 - 2) FINISH: N/A
 - 3) HEAT TREAT: N/A
 - 4) SPEC: N/A
 - 5) BREAK ALL SHARP EDGES: N/A
 - 6) IDENTIFICATION: N/A
 - 7) PRESS FIT RB T101529-137 INTO RB T101529-21

DART AEROSPACE Huntsbury, Ontario, Canada			
TITLE: BASE 2 ASSY			
REV: A			
PART NO.: RB T101529-135			
DESIGN BY: VM 9/11/2017	CHECKED BY: VM 10/23/2017	DATE: 10/23/2017	SCALE: NTS
DRAWN BY: VM 10/23/2017	CHECKED BY: VM 10/23/2017	DATE: 10/23/2017	SCALE: NTS
1. DIMENSIONS ARE IN INCHES 2. UNLESS OTHERWISE SPECIFIED 3. INTERFERES AND TOL PER 4. DIMENSIONAL LIMITS APPLY 5. AFTER PLATING			
WEIGHT: N/A SHEET 8 OF 12 COPYRIGHT © 2017 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE LOANED, REPRODUCED, COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.			

8 7 6 5 4 3 2 1

D
C
B
A

D
C
B
A

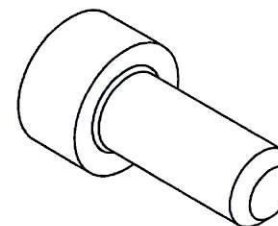
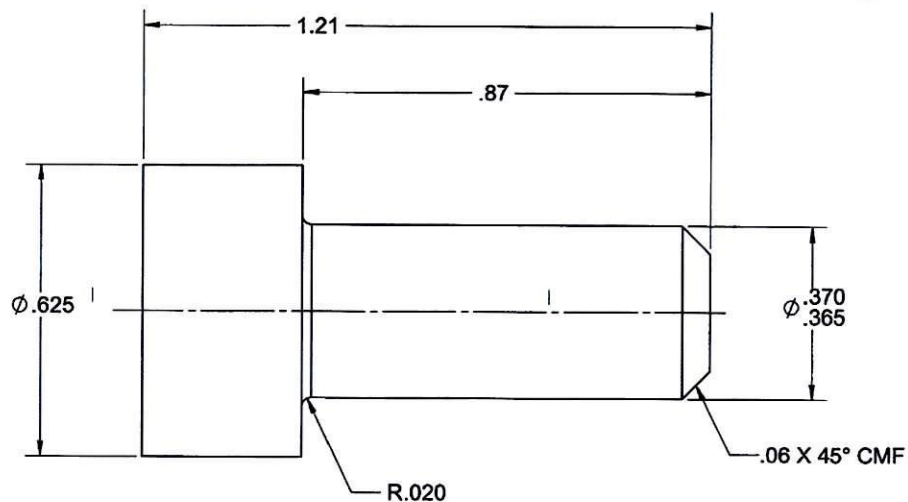
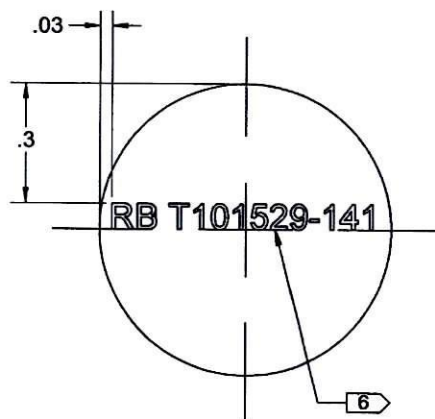


RB T101529-21 BASE 2

- NOTES:
- 1) MATERIAL: AISI 4130
 - 2) HEAT TREAT: 25 Rc
 - 3) FINISH: N/A
 - 4) SPEC: N/A
 - 5) BREAK ALL SHARP EDGES .015 x 45° OR .015R
 - 6) IDENTIFICATION: MACHINE ENGRAVE "RB T101529-21", ARIAL REGULAR, 0.09" HEIGHT, 0.010" DEPTH

BASE 2			
RB T101529-21			
DESIGN BY:	VM 9/11/2017	XXX ± .005 FRACTIONS 2 1/8	REV A
DRAWN BY:	VM 10/23/2017	XX ± .01 ANGLES 5.5°	
CHECKED:	SAC 10/23/2017	1. DIMENSIONS ARE IN INCHES	
APPROVED:	DP 10/30/2017	2. INTERPRET DIM AND TOL PER ASME Y14.5M-2009	
DATE:	10/23/2017	3. DIMENSIONAL LIMITS APPLY AFTER PLATING	
SCALE:	NTS	WEIGHT: 0.6 LBS	SHEET 9 OF 12
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8 7 6 5 4 3 2 1



RB T101529-141 PILOT

NOTES:

- 1) MATERIAL: AISI 4130
- 2) HEAT TREAT: 25 Rc
- 3) FINISH: N/A
- 4) SPEC: N/A
- 5) BREAK ALL SHARP EDGES .015 x 45° OR .015R
- 6) IDENTIFICATION: MACHINE ENGRAVE "RB T101529-141", ARIAL REGULAR, 0.06" HEIGHT, 0.010" DEPTH

DART AEROSPACE		Huntsbury, Ontario, Canada	
PILOT			
TITLE		REV A	
PART NO.		RB T101529-141	
DESIGN BY:	VM 9/11/2017	XXX ± .005	FRACTIONS 2/16
DRAWN BY:	VM 10/23/2017	XX ± .01	ANGLES 2.5°
CHECKED:	SAC 10/23/2017	X	SURFACES = 12
MFG. APPR:	DP 10/26/2017	1. DIMENSIONS ARE IN INCHES	
APPROVED:	WM 11/02/2017	UNLESS OTHERWISE SPECIFIED	
DATE:	10/23/2017	2. INTERPRET DIM AND TOL PER	
SCALE:	NTS	ASME Y14.5M-2009	
WEIGHT:	0.1 LBS	3. DIMENSIONAL LIMITS APPLY	
		AFTER PLATING	
		SHEET 10 OF 12	
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8 7 6 5 4 3 2 1

D

C

B

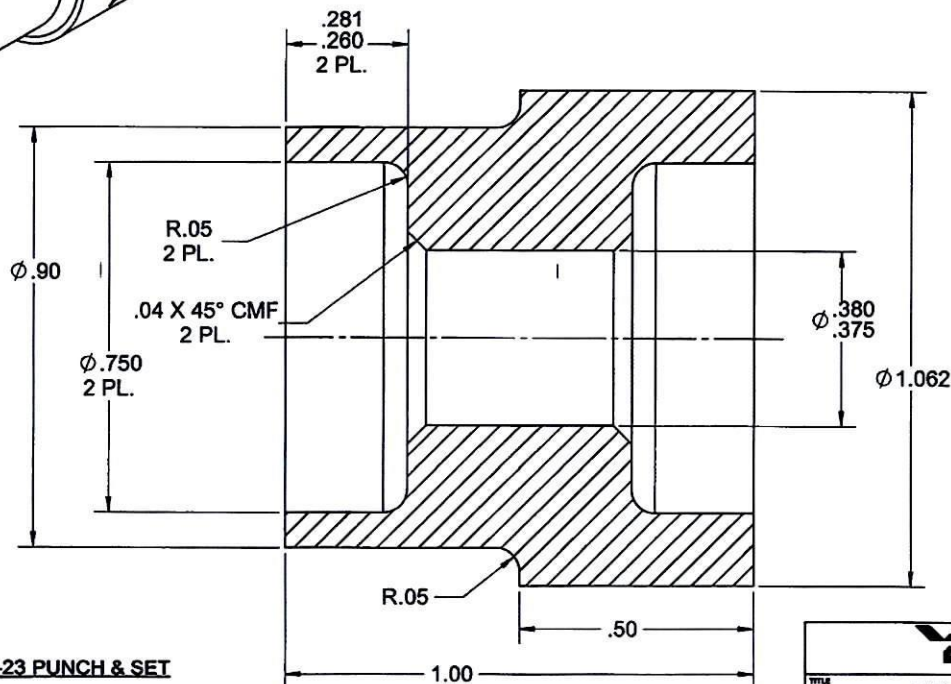
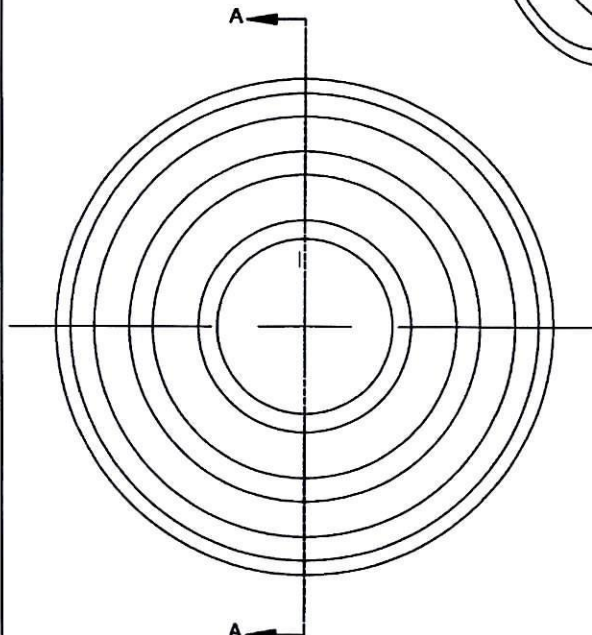
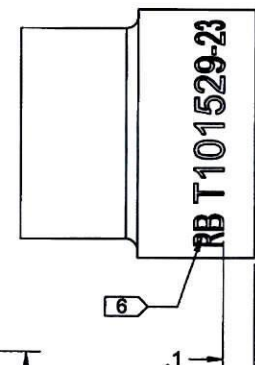
A

D

C

B

A



RB T101529-23 PUNCH & SET

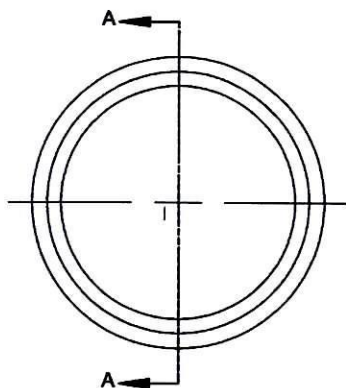
SECTION A-A

NOTES:

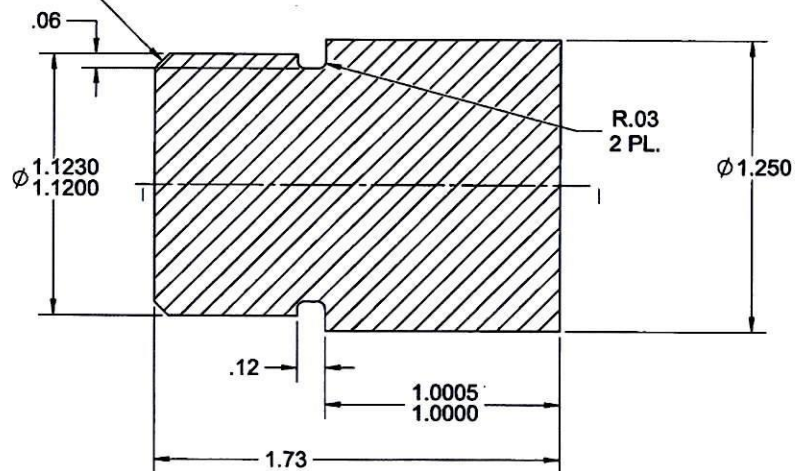
- 1) MATERIAL: AISI 4130
- 2) HEAT TREAT: 25 Rc
- 3) FINISH: N/A
- 4) SPEC: N/A
- 5) BREAK ALL SHARP EDGES .015 x 45° OR .015R
- 6) IDENTIFICATION: MACHINE ENGRAVE RB T101529-23, ARIAL REGULAR, 1/8" HEIGHT, 0.010" DEPTH

DART AEROSPACE Newbury, Ontario, Canada			
TITLE PUNCH & SET			
PART NO. RB T101529-23			
DESIGN BY:	VM 9/11/2017	XXX ± .005 FRACTIONS & 1/8"	REV A
DRAWN BY:	VM 10/23/2017	XX ± .01 ANGLES & 1/8"	
CHECKED:	SAC 10/23/2017	XX ± .01 SURFACES ± 1/8"	
MPG APPR:	DP 10/30/2017	1. DIMENSIONS ARE IN INCHES UNLESS OTHERWISE SPECIFIED	
APPROVED:	WM 11/02/2017	2. INTERPRET DIM AND TOL PER ASME Y14.5M-2009	
DATE:	10/23/2017	3. DIMENSIONAL LIMITS APPLY AFTER PLATING	
SCALE:	NTS	WEIGHT:	0.1 LBS
		SHEET 11 OF 12	
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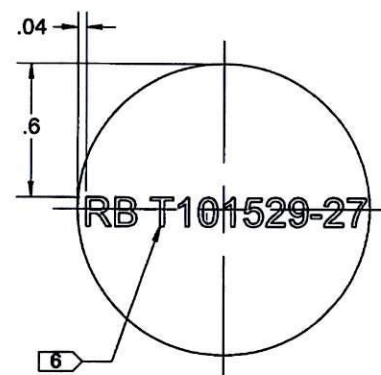
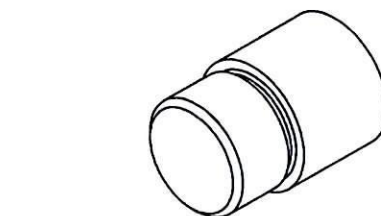
8 7 6 5 4 3 2 1



.06 X 45° CMF



SECTION A-A



RB T101529-27 SUPPORT

NOTES:

- 1) MATERIAL: AISI 4130
- 2) HEAT TREAT: 25 Rc
- 3) FINISH: N/A
- 4) SPEC: N/A
- 5) BREAK ALL SHARP EDGES .015 x 45° OR .015R
- 6) IDENTIFICATION: MACHINE ENGRAVE "RB T101529-27", ARIAL REGULAR, 1/8" HEIGHT, 0.010" DEPTH

DART AEROSPACE Hawkesbury, Ontario, Canada	
TITLE SUPPORT	
PART NO. RB T101529-27	
REV A	
DESIGN BY: VM 9/11/2017	XXX 2 .003 FRACTIONS & 1/8
DRAWN BY: VM 10/23/2017	XX 2 .01 ANGLES & 1/8
CHECKED: SAC 10/23/2017	X 2 .1 SURFACES & 1/8
MFG. APPR: DP 10/30/2017	1. DIMENSIONS ARE IN INCHES
APPROVED: VM 11/02/2017	UNLESS OTHERWISE SPECIFIED
DATE: 10/23/2017	2. INTERPRET DIM AND TOL PER ASME Y14.5-2009
	3. DIMENSIONAL LIMITS APPLY AFTER PLATING
SCALE: NTS	WEIGHT: 0.5 LBS
SHEET 12 OF 12	
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20 Terry Fox Drive
 Vankeek Hill, Ontario K0B 1R0, Canada
 Tel: (613) 678-3957
 Fax: (613) 678-3956

Delivery Slip No.: 22013
 Date: Dec 22, 2017
 Page: 1

Sold to:	Dart Aerospace Ltd. Attn: Linda Lacelle 1270 Aberdeen Street Hawkesbury, Ontario K6A 1K7
Order No.:	PO038295
Shipped By:	your truck
Ship Date:	Dec 22, 2017
Sold By:	Walz, Christian D.
Ship to:	

Description			
Unit	Ordered quantity	Shipped quantity	Backorder quantity
Each	1	1	
Roll Stake Tool, Rotor Blade, drawing # RB T101529-131 Rev.A ***price TBD*** The delivered goods must be inspected upon receipt to confirm compliance. Should there be discrepancies please notify METEC within 30 days of delivery. The goods are otherwise deemed accepted.			
Received by _____ Thank you for your order!			



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER PO038295

Supplier: MEM001-VC
Metec Metal Technology Inc.
20 Terry Fox Drive PO Box 781
Vankleek Hill
ON
K0B 1R0 Canada
Phone: 613 678 3957
Fax: 613 678 3956

Attention: Walz, Shigi

Ship To: 1270 Aberdeen Street
Hawkesbury
ON
K6A 1K7 Canada
Phone: 613-632-5200

PO No: PO038295

PO Date: 11/8/17

Due Date: 1/10/18

Purchase Order

Revision:

Revision Date:

Ship-To Contact: Lavoie, Chantal
Phone: clavoie@dartaero.com

E-MAILED

JAN 10 2018

Via: Ground

Pymt Terms: Net 30

Freight Terms:

Special Comments:

Items

Line Item	Part	Supplier Part No	Item No	Description	Status	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
1	RB T101529- 131P			Staking Tool Set	Firmed	1/10/18	1 pcs	0 pcs	1 pcs	\$1,852.00/pcs	\$1,852.00

Line Item Note B167907

Grand Total: \$1,852.00

Order Notes

Procurement Quality Clauses
A005 RIGHT OF ENTRY
A008 FIRST ARTICLE INSPECTION (FAI) BY SELLER, (DOCUMENTATION SENT TO DART AEROSPACE)
A012 CHEMICAL AND PHYSICAL TEST REPORTS
A016 PERSONNEL QUALIFICATION
A017 RAW MATERIAL IDENTIFICATION (AS APPLICABLE)
A026 CERTIFICATION OF MATERIAL CONFORMANCE
A041 QUALITY MANAGEMENT SYSTEM
A042 DART NOTIFICATION BY SUPPLIER
A043 RETENTION OF QUALITY DOCUMENT

A048 COUNTERFEIT PARTS AVOIDANCE, DETECTION, MITIGATION AND DISPOSITION PROGRAM
A049 SUPPLIER AWARENESS

Terms & Condition of Purchasing(Suppliers) and Procurement Quality Clauses are an integral part of our AS9100 requirements. To learn in detail, please visit www.dartaerospace.com for further explanation.

Plex 1/10/18 7:46 AM dart.lavoie.chantal



20 Terry Fox Drive, Vankleek Hill, Ontario K0B 1R0

Tel. (613) 678-3957 & (613) 678-2782 Fax (613) 678-3956 metec@metec.ca

CERTIFICATE OF CONFORMITY

SOLD TO:

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, Ont.
K6A 1K7

SHIPPED TO:

same

Quantity	Part Number	Part Name	P.O. Number
1	RB T101529-131 Rev.A	Staking Tool Set	38295

We hereby certify that the above parts were made in conformance with applicable drawings.

METEC Metal Technology Inc.


Shigi Walz

Vankleek Hill, Dec 22, 2017